

Work Order ID 56089

February 10, 2010 12:11:55 PM

Page 1

Item ID: D350-591-312

Revision ID:

Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10 Start Qty: 5.00

Required Date: 2/26/10 Req'd Qty: 5.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-312 Q141001

0.00

0.00

110



Large Fab

Large Fab

Large Fab

Memo

1-Bevel end for welding FWD ONLY

0.00

0.00

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod 1/10/35

3-Grind End Plate flush

Non-subcontract



Accept



Setup Start



Stop



Cust Item ID:

Customer:



Sololos
002

Helen CL 10/03/03

10.02.24 5

Work Order ID 56089

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Page 2

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10 Start Qty: 5.00

Required Date: 2/26/10 Req'd Qty: 5.00

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

Work Order ID 56089

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Page 3

Item ID: D350-591-312

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Stop

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Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

0.00

QC

Memo

Quality Control

180

0.00

Large Fab

Large Fab

0.00

Memo

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod. M11311

6-Grind End Plate flush

7-Install last rivet as per Dwg.

Work Order ID 56089

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Page 4

Item ID: D350-591-312

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Setup Start

Revision ID:

Stop

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Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

3 10.02.26

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sider 2c



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/05/09

X5R11

Work Order ID 56089

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Setup Start

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Stop

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Cust Item ID:

Required Date: 2/26/10 Req'd Qty: 5.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00:00

OVEN TEMPERATURE: 300°F

FINISH TIME: 10:20:00

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

240

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Pen/3/3 (1)

Work Order ID 56089

Wednesday, March 03, 2010 3:13:51 PM

Page 6

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 2/26/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

10-3-3 SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

S. Wilson

41
RH

270



Packaging

Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPPD350-591-312

Location: _____

Rev. B

10-3-3 SP

Work Order ID 56089

Wednesday, March 03, 2010 3:13:51 PM

Page 7

Item ID: D350-591-312

Accept

Setup Start

Revision ID:

Stop

Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 2/26/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03

MF
10-3-3

Picklist Print

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Page 1

Work Order ID: 56089



Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A: 04.03.22 New issue: KJ/RP:
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

D3065-041 Manufactured No



Step Leg Assembly Hi

Each 60.0000 5.0000



1/2 10.00.25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

60

53795

30

55450

30

Each

42.0000

10.0000



1/2 10.00.25

D3066-1 Manufactured No



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

42

51545

11

53783

31

Each

62.0000

10.0000



1/2 10.00.24

D3219-1 Manufactured No



Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

62

53789

62

10

Picklist Print

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Work Order ID: 56089



Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue (KJ/RF)
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

D3067-1 Manufactured No

110 Each 53.0000 5.0000



End Plate

1/6 10-02-24

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

53

53784

53

D3272-1 Manufactured No

110 Each 0.0000 5.0000



Step

Purchased No

110 Each 459.0000 10.0000



Nut

10-02-24 356041

10-3-3

sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

458

110382

10

111636

1

112314

20

113523

227

113537

200

Main Warehouse

ST139

1

112314

1

2

(*)

Picklist Print

February 10, 2010 12:11:59 PM

Work Order ID: 56089



Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue i KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

MS20600-AD4W4

Purchased No

180

Each

1,203.000 80.0000



Rivets

Handwritten: 10-00-25

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1203

110731

215

111359

46

111477

74

112314

344

112385

24

113368

500

Purchased

No

260

Each

201.0000 10.0000



Bolt

Handwritten: 10-3-3 50 (R)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

201

106993

12

110467

1

112314

188

Handwritten: 2

Picklist Print

February 10, 2010 12:11:59 PM

Work Order ID: 56089

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments: IPP Rev:A 04.03.22 New issue: KJ/RP:
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Purchased No

260 Each

269.0000 40.0000

10-3-3 *SP*

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

269

113359

69

113749

200

17406

0

51764

0

Purchased

No

260 Each

115.0000 10.0000

10-3-3 *SP*

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

109545

11

110467

7

110731

4

112243

20

112314

23

112385

50

Purchased

No

260 Each

0.0000 20.0000

1113288 10-3-3 *SP* (12)

Washer

Picklist Print

February 10, 2010 12:11:59 PM

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Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RF:
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

Purchased No

260 Each 0.0000 80.0000

Purchased No

260 Each 0.0000 20.0000

Manufactured No

260 Each 13.0000 20.0000

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST176

5

53881

5

Main Warehouse

ST476

1

53781

1

B55310 10-3-3 P

M113706 10-3-3 S

M113524 10-3-3 S

12

February 10, 2010 12:11:59 PM

Shop Packet Print

Picklist Print

February 10, 2010 12:11:59 PM

Work Order ID: 56089

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments: IPP Rev:A 04.03.22 New issue: KJ/RF.
IPP Rev:B 07-06-09 Added D3572-1 JLM
IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Manufactured No

260

Each

61.0000

10.0000

10-3-3 *sf*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST39

61

50989

61

260

f

264.9521

3.0000

2
10-3-3 *sf*

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

264.9520842

50593

141.312084

52563

123.64

260

Each

53.0000

5.0000

14
25
10-02-25

Manufactured No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

53

53784

53

5

Sxl *12*
Bushing

Sxl *2856-400* *1* *20* *720"*
Abraison Strip

D3067-1
End Plate

Picklist Print

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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue. KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Manufactured No

260 Each 47.0000 10.0000



10-3-3 sl

SA 35-1; KR
 Mounting Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47

45398

4

54756

43

2

Manufactured No

260 Each 63.0000 5.0000



10-3-3

sl

SA 8-011; XI
 Support Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

53227

23

Main Warehouse

ST471

40

55318

40

1

10

Picklist Print

February 10, 2010 12:11:59 PM

Work Order ID: 56089



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Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22 New issue KJ/RFI
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC



Nut

Purchased No

260

Each

2,681.000 10.0000



10-3-3

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2675

110844

35

111274

27

111668

52

112314

289

112385

498

113523

74

113537

700

113644

1000

Main Warehouse

ST139

6

111668

6

Picklist Print

February 10, 2010 12:11:59 PM

Work Order ID: 56089



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Parent Item Name: Heli-Access-Step, Long RH

Start Date: 2/10/10

Required Date: 2/26/10

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A 04.03.22: New issue + KJ/RF
 IPP Rev:B 07-06-09 Added D3572-1 JLM
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

MS210421.4

K2

Purchased No

260

Each

2,535.000 40.0000



10-3-3 SP

(K)



Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2535

102552

6

104248

6

110507

184

~~111827~~

1339

113422

1000

15924

0

W

6-1

DSE 9410 Alt

for chg 002

2 x

B/N

B56637 A1

SE

DART

DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED*07.06.04*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

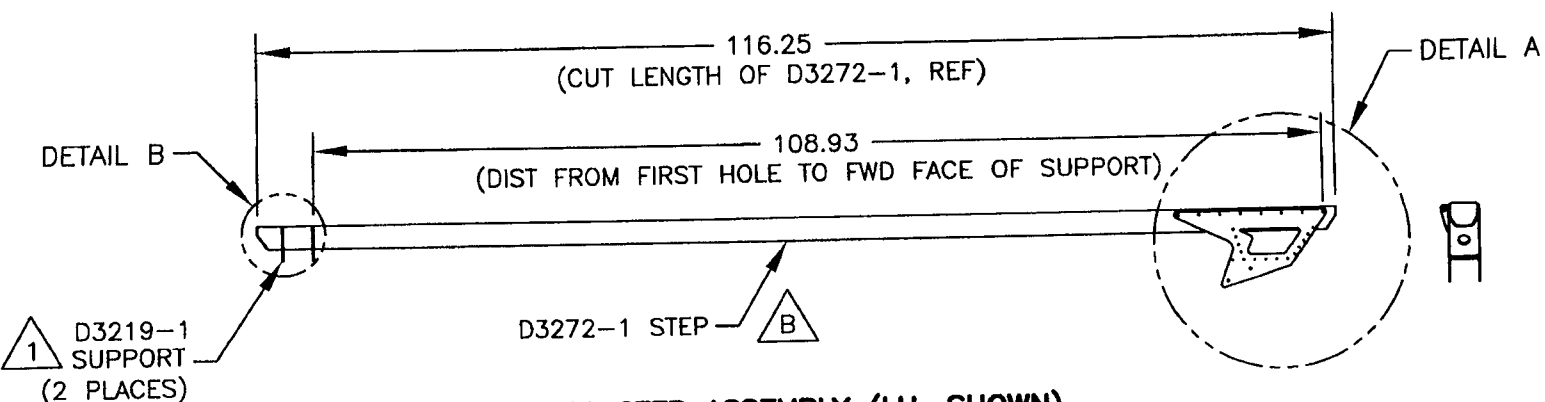
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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *266679*

BH 10-2-10

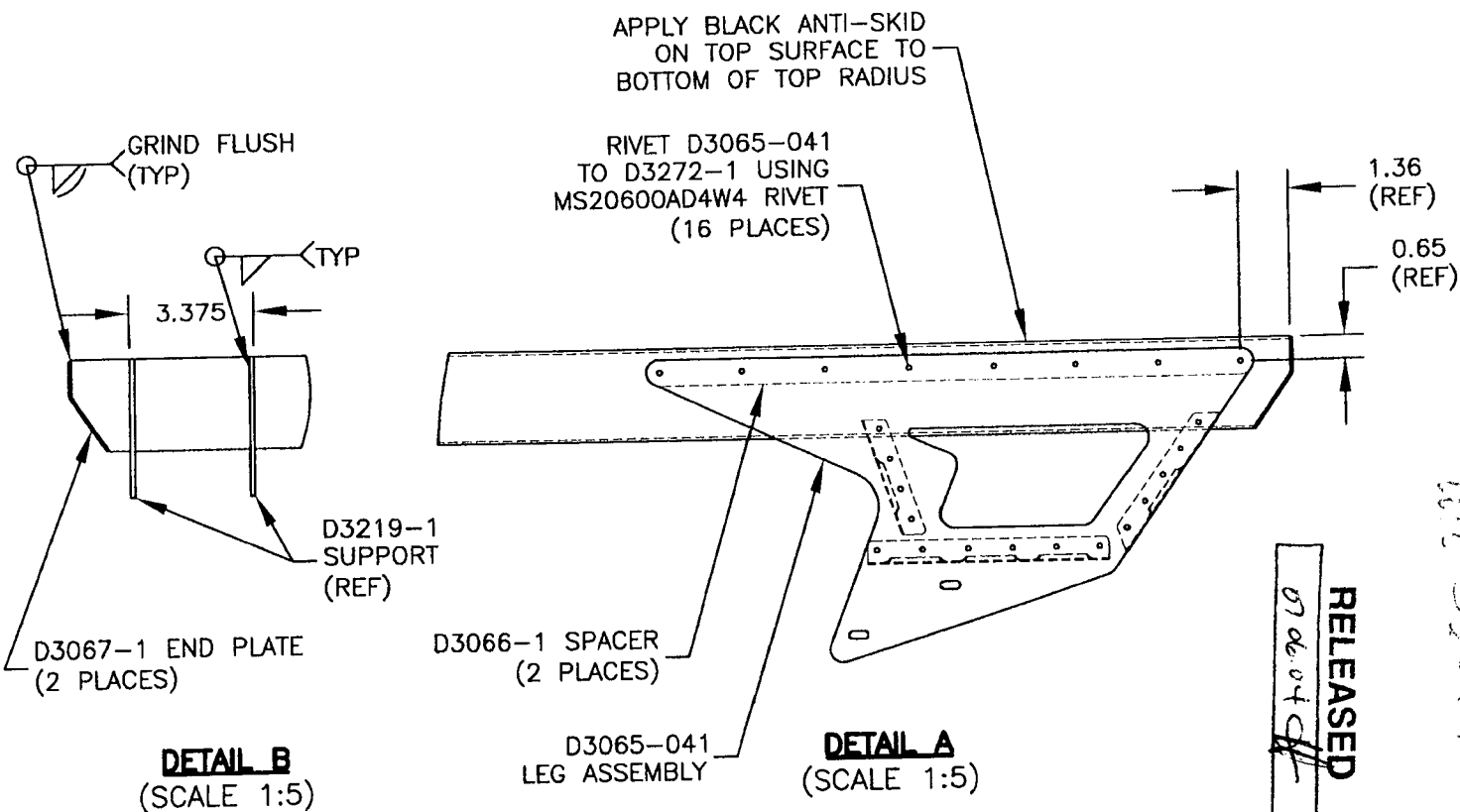
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DESIGN	99	DRAWN BY	99	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	CE	REV. B
DATE	07.05.18	DRAWING NO.	D3272	SHEET 2 OF 3
		TITLE	STEP ASSEMBLY, HI LONG	SCALE 1:20

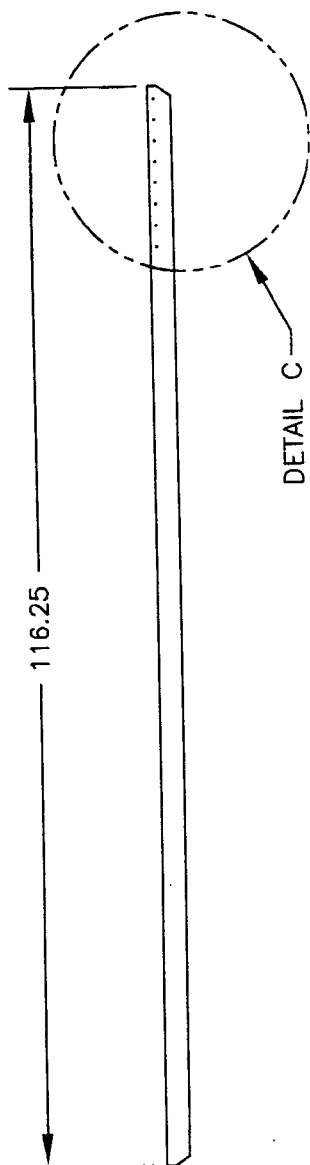


DESIGN 90	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20

10/0 56089

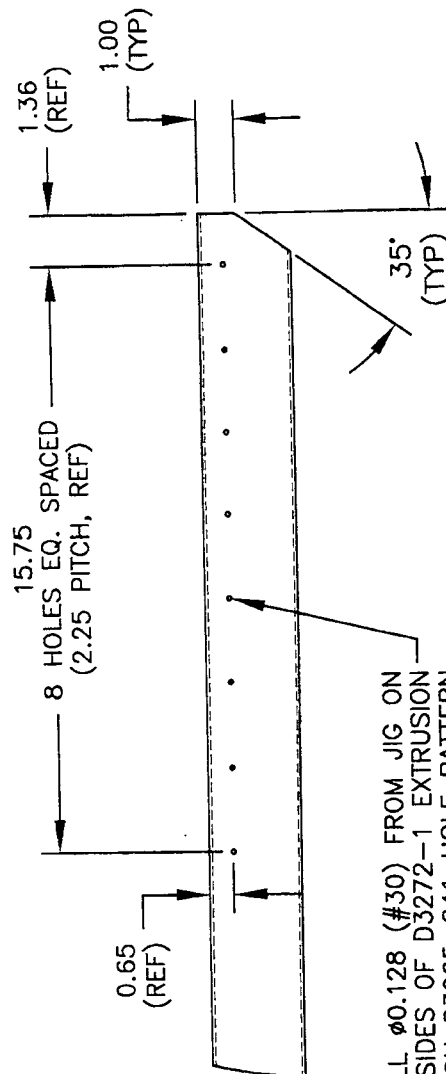
RELEASED

07.06.04



DETAIL C

B D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8					2	2	D2274	RADIUS BLOCK
								D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries